

Title (en)  
Insert for milling of cast iron

Title (de)  
Einsatz zum Fräsen eines Gussstückes

Title (fr)  
Insert pour le fraisage d'une fonte d'acier

Publication  
**EP 1867741 B1 20090826 (EN)**

Application  
**EP 07108111 A 20070514**

Priority  
SE 0601312 A 20060615

Abstract (en)  
[origin: EP1867741A1] The present invention relates to a coated cemented carbide milling insert for either wet or dry machining of cast iron such as nodular cast iron (NCI), grey cast iron (GCI), austempered ductile iron (ADI) and compacted graphite iron (CGI) where a high wear resistance and an excellent resistance against thermo cracks are required comprising: -a substrate comprising 5-7 wt-% Co, 140-250 ppm Ti+Ta and balance WC with a weight ratio Ti/Ta of 0.8-1.3 and -a PVD-layer consisting of Al x Ti 1-x N, with x 0.50-0.70 and with a thickness of 1-10 µm. The invention also relates to a method for making cutting tool inserts.

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